PRODUCT SPECIFICATION

Modi Lastek 801

Resistant to intergranular – and pitting corrosion

GENERAL DESCRIPTION

Stabilized stainless electrode for applications at higher temperatures (up to 400°C (750°F)).
Joining of austenitic stainless steel containing Molybdenum:
a) stabilized with Ti or Nb, as AISI 318, 316Nb, 316Ti, Wn° 1.4580, 1.4571, 1.4583, BS 320 S17, 320 S31, 320 S33, 318 S96, 318, C17
b) low carbon, as AISI 316, 316LN, Wn° 1.4401, 1.4436, 1.4449, 1.4404, 1.4435, 1.4438, 1.4406, 1.4429
Quiet arc, good control of the molten pool. No spatter.
If the weld metal has to be polished to a high degree, use Modi Lastek 804.

APPLICATIONS

Paint-industry, weaving-mills, photo-laboratories, food industry (dairy factories, breweries), constructions exposed to sea-water.

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

C : < 0.04	Si : < 1.00	Mn : 0.70	Cr : 18.50	Ni : 11.50
Mo : 2.70	Nb : > 8 x % C			

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm²	Tensile Strength N/mm²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 400 MPa	≥ 590 MPa	≥ 30 %	≥ 47 J (20°C)

GENERAL INFORMATION

Welding positions	All, except vertical down		
Shielding gas	NA		
Packing	5 Kg in a plastic box		
Polarity	Ac or DC, reverse polarity (electrode positive)		
Diameter (mm)	2.0	2.5	3.2
Length (mm)	300	300	350
Approx. current (A)	25 - 40	50 - 70	60 – 90

Tips & Tricks Very low amperage, short arc; use dry electrodes.